

Date: Friday, 9/29/2006 10:43:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT ASSEMBLY
Job Number	: 28793		
Estimate Number	: 11248		
P.O. Number	: N/A	Part Number	: D3438042
This Issue	: 9/29/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3438 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27651	Drawing Revision	: A
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 10/15/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	2
Comment	: Est A05.05.18 New Issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	<u>325396</u>

2.0	D2561	Lug Plate
-----	-------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	<u>324461</u>

3.0	D2564	Mounting Angle
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	<u>327418</u>

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63" at 34° as per Dwg D3438

323404

2-Deburr ends

3-Weld one cap as per Dwg D3438 using DT8343

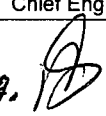
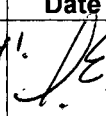
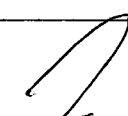
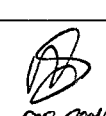

323404 323404 323404

323404 323404 323404

323404 323404 323404

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-04	4.0	1x D2561 Lug went crooked. Not square to step during welding. S.g.was used. Lug off by roughly .200" from side to side, Lug not welded completely	 06/10/12	Remove & replace Lug Qty 1. Weld as per QS 1004, and ensure no cracks in mat'l after lug reinstalled.	 06-10-4	 06-10-11 06/10/11	 06/10/12	 06-10-04

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Grind

FE-06-10-04 2

5.0

QC5/9

WELD INSPECTION



FE-10-11 (2)



Comment: WELD INSPECTION

06/10/11 (2)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06 10 17 (2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE-06-10-18 2

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last cap per dwg D3438 & grind flush

FE-06-10-18 2

9.0

QC5/9

WELD INSPECTION



FE-10-20



Comment: WELD INSPECTION

06/10/18 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Touch up alodine

a.m 06/11/07 (2)

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/11/07 (2)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

M102098

a.m 06/11/07 (2)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/11/10 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A 10/6/11/10

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

10/6/11/13

Job Completion



C Log 11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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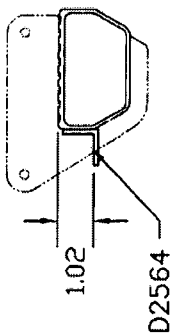
NOTE: Date & initial all entries

DART

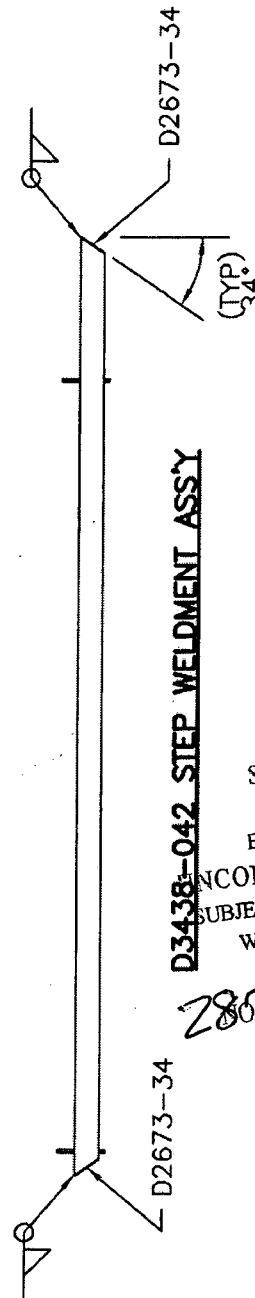
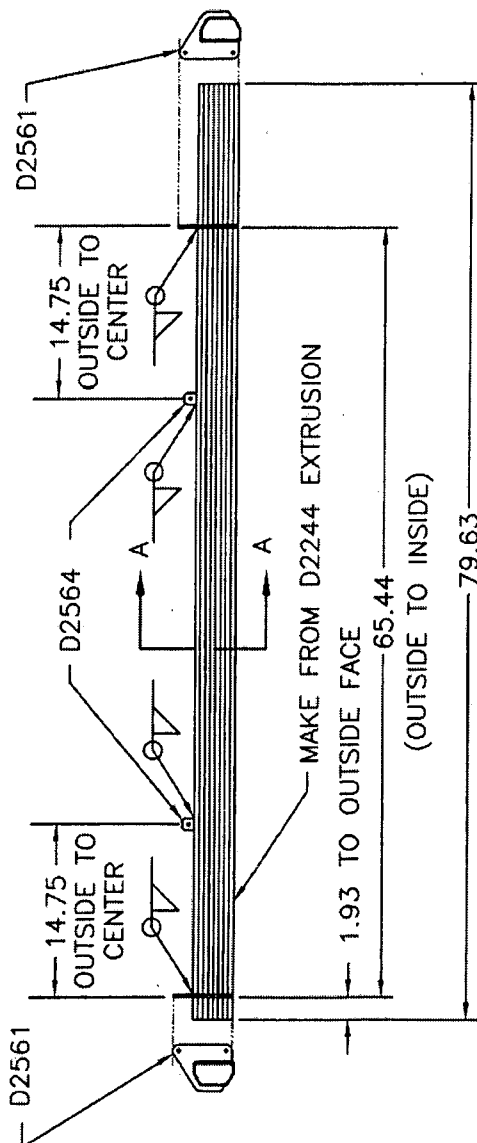
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09	TITLE STEP WELDMENT ASSEMBLY		SCALE 1:1
A	05.05.09	NEW ISSUE	

RELEASED

05-05-22



SECTION A-A

**D3438-042 STEP WELDMENT ASSY**SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

280193

NOTES:

- 1) WELD PER DART QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1
- 2) TOLERANCES ARE PER DART QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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